

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 89643





Tuesday, August 28, 2012 4:33:05 PM

89643

Page 2

Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, RH
Start Date: 8/28/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/6/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3 Inspect Part Finish QC7 Memo	0.00 0.00				1			
140 *140* Small Fab Small Fab	Small Fab Memo 1- Drill Rivet holes as per dwg D3562. Touch up alodine 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: <u>120666</u>	0.00 0.00				1			 12.09.07
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			

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Tuesday, August 28, 2012 4:33:05 PM

89643

Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step Assembly, RH

Stop ***NS2***

Start Date: 8/28/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/6/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/RAluminum Rod 122358

2-Grind end cap welds flush as per Dwg D3562

1 0 1209.07

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

DAS
16
9-6

12/09/10

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
16
9-6

12/09/10

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Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

190

HandFinish
Hand Finishing

Memo

0.00

1 78 129.10

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

200

Powdercoat
Powder Coating

Memo

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

3:45
320°F
4:15

0.00

1X 12/09/10

210	Wing Walk as per dwg QSI005 4.4 Batch 11173200	0.00							
-----	--	------	--	--	--	--	--	--	--

210

HandFinish
Hand Finishing

Memo

0.00

13H 12/09/11

1121841

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Tuesday, August 28, 2012 4:33:05 PM

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Page 5

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220						1	0	12-9-11	
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

MF
12-09-11

Dart Aerospace Ltd

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Picklist Print

Tuesday, August 28, 2012 4:33:05 PM

Page 1

Work Order ID: 89643

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 8/28/2012

Required Date: 9/6/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	48.7900	1	1		8/12.09.07	

Location	Loc Qty	Loc Code
HALL	388513	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	23.06	
81507	2.88	
83894	20.18	
WA013	9.36	
75781	2	
77612	7.36	

D2734
Step End Plate

Manufactured No

140 Each 118.0000

2 2

8/12.09.07

Location	Loc Qty	Loc Code
WA	118	
80682	8	
84563	27	
88089	38	
88714	45	

D3560-042
Arm Weldment

Manufactured No

140 Each 0.0000

1 1

8/12.09.07

385384 = ①

Dart Aerospace Ltd

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Picklist Print

Tuesday, August 28, 2012 4:33:05 PM

Page 2

Work Order ID: 89643

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 8/28/2012

Required Date: 9/6/2012

Start Qty: 1.00

Required Qty: 1.00

D3560-044
Arm Weldment

Manufactured No

140 Each 1.0000

1

1


12.09.07
12.09.07

Location Loc Qty Loc Code

WA013 1

71950 1

1

 MS20600-AD4W5
Blind Rivet

Purchased No

160 Each 519.0000

32

32

12.09.07

Location Loc Qty Loc Code

ST321 519

121255 19

121349 200

121652 300

32

Tuesday, August 28, 2012 4:33:05 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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D3562-1,
MAKE FROM
EXTRUSION D2622

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-044 ARM WELDMENT

D3560-042 ARM WELDMENT

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

TRANSFER DRILL #30
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING
(32 PLACES PER STEP)

REFER TO STEP
END DETAIL

INSTALL MS20600AD4W5 RIVET
(32 PLACES PER STEP)

4.30 71.707 9.15
(REF)

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

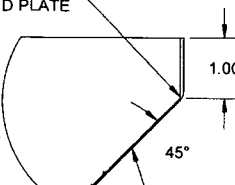
9.15 71.707 4.30
(REF)

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004



D2734 END PLATE
(TYP 2 PLACES)

TYPICAL STEP END DETAIL
SCALE 1:2

D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3562-041	LH STEP ASSEMBLY
		D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	64		
CHECKED	16		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3562

REV. E
SHEET 1 OF 1

TITLE
STEP ASSEMBLY

SCALE
1:5

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